

Date: Tuesday, 29/04/2008 9:59:51 AM
 User: Melanie Fauteux

OIC

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: UPPER RAIL	
Job Number	: 38866		Part Number	: D37671	
Estimate Number	: 10804		Drawing Number	: PROTOTYPE	
P.O. Number	:		Project Number	:	
This Issue	: 29/04/2008	S.O. No. :	Drawing Revision	: A 08.05.23	
Prsh Rev.	: NC		Material	:	
First Issue	: 29/04/2008	Type :	Due Date	: 16/05/2008	Qty: 2 Um: Each
Previous Run	: 00015				
Written By	:				
Checked & Approved By	:				
Comment	:				

Additional Product

PROTOTYPE

Job Number:		
Seq. #:	Machine Or Operation:	Description :
1.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1 
Comment: SMALL & MEDIUM FAB RESOURCE 1 MAKE PER DRWG D3767 REV A FF 08-05-12 (2)		
2.0	M6061T6T1000W065	6061T6 TUBE 
Comment: Qty.: 2.9300 f(s)/Unit Total : 5.8600 f(s) 6061T6 TUBE FF 08-05-08 (2)		
3.0	QC5	INSPECT WORK TO CURRENT STEP  ENGINEERING APPROVAL S080512C (2) / P4 01.05.14
Comment: INSPECT WORK TO CURRENT STEP		
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1 
Comment: HAND FINISHING RESOURCE #1 ACID ETCH AND ALODINE PER QSI 005 22/M-1 08/05/14 (2)		
5.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION  CERTIFICATE OF CONFORMITY REQUIRED
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION of.05.14		

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Drawing Name: UPPER RAIL

Job Number: 38866

Part Number: D37671

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

GIVE TO CHRIS P-ENG

FOR EXTERNAL USE ONLY

RE
08.05.29

CHARGE TO JOB #00196

7.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

CERTIFICATE OF CONFORMITY

REQUIRED

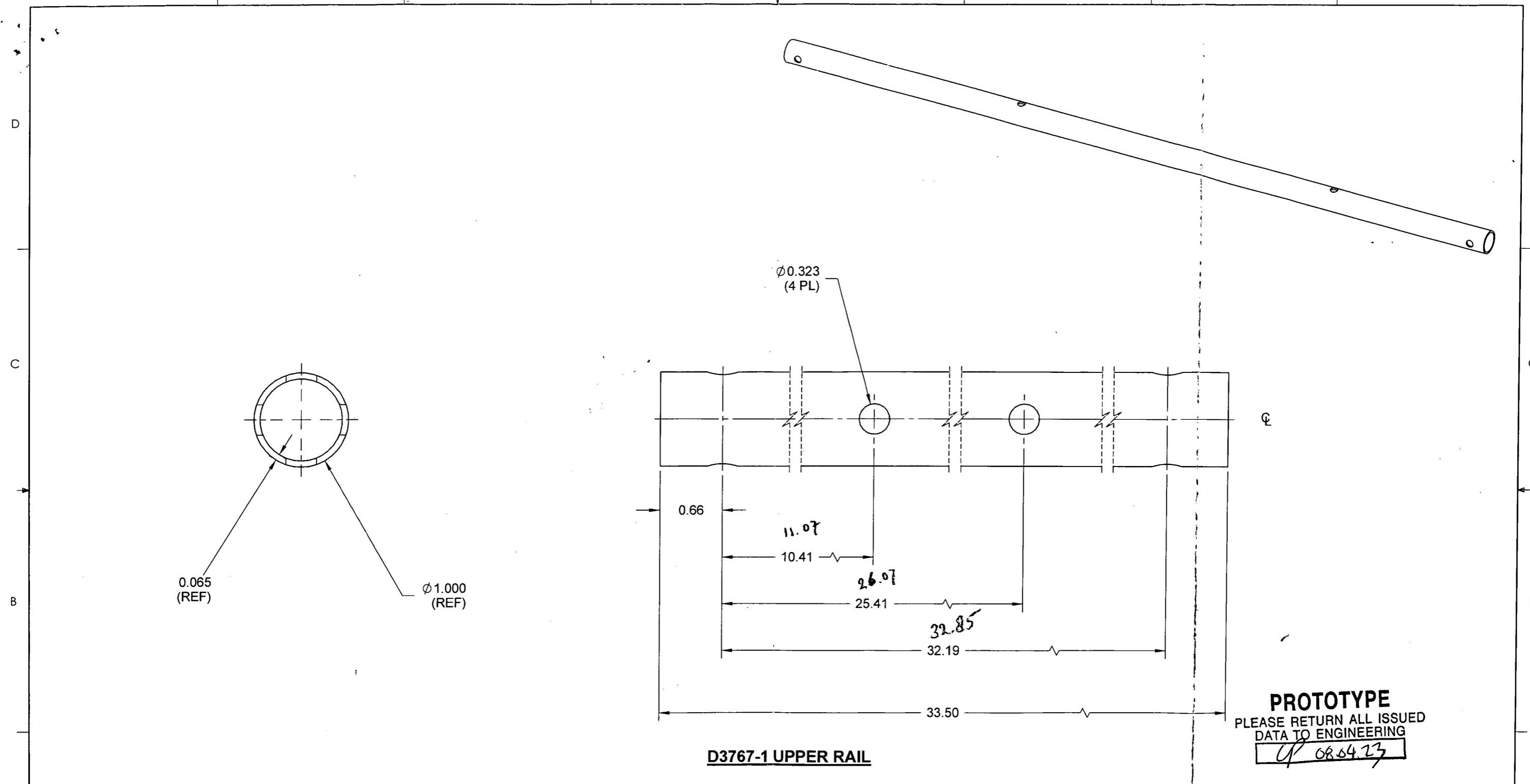
08.05.29 Pre-
08.06.11

Job Completion



08.06.11

8 7 6 5 4 3 2 1



NOTES:

- 1) MATERIAL: 6061-T6 (QQ-A-200/8 OR QQ-A-225/8) ALUMINUM TUBING 1.00" X 0.065" WALL (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.62 lbs

DESIGN	HS	DART AEROSPACE LTD	
DRAWN	HS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3767	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		UPPER RAIL	1:1
DATE	08.03.26	COPYRIGHT © 2008 BY DART AEROSPACE LTD	

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Receiving Report

Date: 8/6Supplier: MARMURBatch No: M107950Dart P/O: 6269
 Packing Slip: Yes No
 Invoice: Yes No
 Receipt: Cash Cr

 Release Note Attached: Yes No N/A
 Waybill Attached: Yes No N/A
 Shipment Complete: Yes No N/A
 QC6 Inspection: 080509 N/A
 Work Order: 080509 N/A

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) LL Level 12

Production/Admin:

Date 08/05/08Received/Costing R/R 7822Initial LLLocation

H:\FORMS\Purchasing\approved purch\RECREPORT Rev D

RECEIVED MAY 09 2008

Energy Surcharge

12.20

ORIGINAL INVOICE / FACTURE ORIGINALE

 TERMS: NET 30 DAYS
 PLUS 2% PER MONTH ON
 OVERDUE ACCOUNTS.

 TERMES: NET 30 JOURS
 PLUS 2% PAR MOIS
 SUR COMPTE PASSE DÜ.

 FOR CONDITIONS OF SALE REFER TO BACK OF INVOICE.
 POUR LES CONDITIONS DE VENTE, VOUS TROUVEREZ LES
 RENSEIGNEMENTS À L'ENDOS DE LA FACTURE ORIGINALE.

G.S.T.	/HST	18.02
T.P.S.		
PROVINCIAL TAX		.00
TAXE PROVINCIALE		

 PAYMENT OF THIS INVOICE IS DUE BY
 LE RÉGLEMENT DE CETTE FACTURE EST EXIGIBLE AU PLUS TARD LE

06/04/2008

378.38

FEB 18 2008 15:44 FR MARMON KEYSTONE

6309722464 TO 14506414357

P.02/03

02/18/2008 From: MARMON/KEYSTONE

M/K OR:
C.P.O.:
C PART:

INIT.:

To:

OR. REF:
SLSPRS:

KAISER
ALUMINUM
FABRICATED PRODUCTS
6573 W. WILLIS ROAD
CHANDLER, AZ 85226

CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

CUSTOMER PO NUMBER:		CUSTOMER PART NUMBER:		PRODUCT DESCRIPTION:					
80-33603		AT11.065734		Seamless Tube					
KAISER ORDER NUMBER:	LINE ITEM:	SHIP DATE:	KAISER LOT NUMBER:	ALLOY:	TEMPER:				
200438	005	11/27/2007	F00000606	6061	T6				
WEIGHT SHIPPED:	QUANTITY:	BL NUMBER:	DIA/WALL THICKNESS:	WIDTH:					LENGTH:
331.000 LB	123.000 PCS	200274							12.000 FT
SHIP TO:		SOLD TO:							
MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA		MARMON/KEYSTONE CORP 10700 MARMON DR BOLINGBROOK, IL 60440 USA							

Actual Physical Properties

REFERENCE	DASH#	SAMPLE#	UTS (ksi)	YTS (ksi)	ELONG%	HARDNESS	COMPLIANCE	SEND
F00000606	0001	3	46.5	42.6	17.0	N/A	N/A	N/A

Chemical Composition (wt%), Aluminum Remainder

LIMITS	Si	Fe	Cu	Mn	Ni	Cr	Zn	Ti	Pb	B1	Er	Ea	Tot
Maximum	0.80	0.70	0.40	0.15	2.20	0.35	0.25	0.15	NA	NA	NA	0.05	0.15
Minimum	0.40	0.00	0.15	0.00	0.80	0.04	0.00	0.00	NA	NA	NA	0.00	0.00
R22453	.62	.39	.22	.05	.92	.06	.03	.02	.00	.01	.00	.00	.00

CERTIFICATION

Kaiser Aluminum Fabricated Products, LLC ("Kaiser") hereby certifies that metal shipped under this order has been inspected and tested and found in conformance with the applicable specifications forming a part of the description set forth in Kaiser's sales acknowledgement form. Any warranty is limited to that shown on Kaiser's general terms & conditions of sale. Test reports are on file subject to examination.

Wilfredo A. delaCruz, Sr. Metallurgical Engineer

Page 1 of 2

Plant Serial: 00000266

Kaiser Order Number: 200438

Line Item: 005

O.C. REVIEWED

PAGE 02

FEB 06 2008 13:10

18 2008 15:44 FR MARMON KEYSTONE
/2008 FROM: MARMON/KEYSTONE

6309722464 TO 1450641537

X OR:
C.P.O.:
C PART:

INIT.:

TO:

OR. REF:
SLSPRS:

KAISER
ALUMINUM
FABRICATED PRODUCTS

KAISER ALUMINUM
FABRICATED PRODUCTS
6573 W. WILLIS ROAD
CHANDLER, AZ 85226

Boggs

CERTIFIED TEST REPORT
<http://www.KaiserAluminum.com>

Applicable Requirements:

Description: OD: 1.000"; Wall: 0.065"; Round
AMS-T-082N ASTM-B210-04 WN-T-700/6F
WE TAKE EXCEPTION TO PARA. 5.2.1. PER AMS 6082N, WAS NOT OILED.
THE FOLLOWING SPECIFICATION HAVE BEEN MADE INACTIVE OR
CANCELLED: MIL-T-7081, WN-T-700E/GEN, WN-T-700/2B, WN-T-700/3F,
WN-T-700/4F, WN-T-700/5B, WN-T-700/6F, WN-T-700/7B.
COMPLIES TO THE REQUIREMENTS OF DIN EN 10204-1
COMPLIES TO DIN EN 10204 JAN 2005

Miscellaneous Notes

MANUFACTURED IN USA MELTED IN USA

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Wilfrido A. de la Cruz, Sr. Metallurgical Engineer

Wilfrido A. de la Cruz

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Plant Serial: 00000264

Kaiser Order Number: 200438

Line Item: 005

PAGE.03

FEB 06 2008 13:11

** TOTAL PAGE.03 **